Page 1

Item ID:

D3272-1

Wednesday, August 24, 2011 9:01:40 AM

Accept



Setup Start



**Revision ID:** 

Start Date:

Item Name:

Step

8/24/2011

**Start Qty:** 10.00 Req'd Qty: 10.00

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Required Date: 9/30/2011

**Tooling:** 

Date:

Run

Start



**Process Plan:** 

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan Accept Qty Code

te 11.09.16 (x10) &

Reject Qty

Reject Number

Stamp

Draw Nbr

**Revision Nbr** 

D3272

Rev B

100

Large Fab Large Fab

Large Fab

Memo

0.00

0.00

\*\*\*SOUARE ONE END BEFORE CUTTING OTHER END\*\*\*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting

table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

QC6- Inspect dimensions to drawing

0.00

al ul orlie

Memo

0.00

Quality Control

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:	NCI	R: Yes	No DQA	\:	Date:	
	R	esolution:	Dispositi	on:	_ QA:	N/C Cld	sed:		Date:	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE	(NCR	)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	ion B	Sign &	Verific	ation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector

#### Work Order ID 73027

Wednesday, August 24, 2011 9:01:40 AM

Item ID:

D3272-1

**Revision ID:** Item Name:

Step

**Start Date:** 

8/24/2011

Required Date: 9/30/2011 Req'd Qty: 10.00

Reference:

Approvals:

**Process Plan:** 

QC:

Date:

Date:

**Tooling:** 

Accept

SPC (Y/N):

**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Date: Date: Run

Stop

Reject

Qty

Start

Setup Start

Stop

Reject

Number

Sequence ID/ **Work Center ID** 

120

Packaging

Packaging

Operation Description

Start Qty: 10.00

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool # Plan

Code

Accept

Qty

130

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

M9/22 X) MF 1-09-22

Insp.

Stamp

		- <del></del>							
W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposition	):	QA: N/C CI	osed:		_ Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			,
DATE		Description of NC		Corrective Action Section B		Verificati	ion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
				·					

#### **Picklist Print**

Wednesday, August 24, 2011 9:01:38 AM

Work Order ID: 73027

Parent Item:

D3272-1

Parent Item Name: Step



Start Date: 8/24/2011

**Start Qty: 10.00** 

Required Date: 9/30/2011

Required Qty: 10.00

**Comments:** 

IPP Rev:A

New Issue 07-06-09

JLM

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Last Location

Route Seq ID Unit of Measure Hand

Qty on

Qty per Kit Total

Qty

Qty Issued Date Status Issued

D2622-120C

Manufactured

No

100

Each

74.7000

10 

11.09.14.

Step Extrusion

Locati	<u>on</u>	Loc Qty		Loc Code
HALL		65		
	64409	6		
	68293	59	1	
WA		9.7		
	46910	2		
	66970	7 7		



W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PR	OCEDURE CHA	ANGE	By Date C			Approval Chief Eng / Prod Mgr Approva QC Inspect		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA	\:	Date: _		
	Re	esolution:	Dispositio	on:	QA: N/C Ck	osed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector	
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DESIG	m	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHECK	(ED	APPROVED	DRAWING NO.	REV. B
<b> </b>	E	故	D3272	SHEET 1 OF 3
DATE			TITLE	SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

OT Ob out of

QTY	QTY	DA DE NUMBER	DESCRIPTION
-041	-042	PART NUMBER	DESCRIPTION
Χ		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

#### **GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

13027

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	<b>A:</b>	_ Date: _	
	Re	solution:	Dispositio	n:	_ QA: N/C Cld	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector

D3272 TITLE

SHEET 2 OF 3

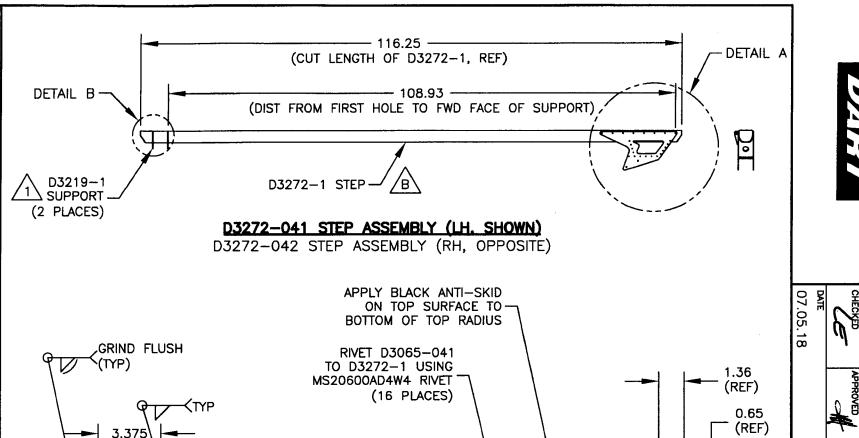
SCALE 1:20

REV. B

STEP ASSEMBLY, HI LONG

DRAWING NO.

RT AEROSPACE I



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DOCUMENT

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PURPOSE

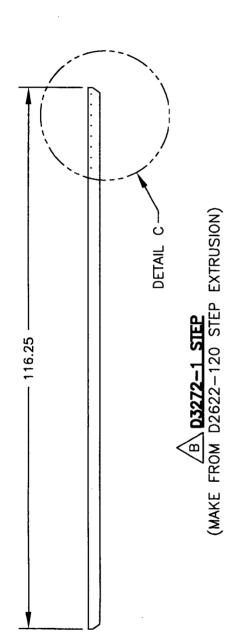
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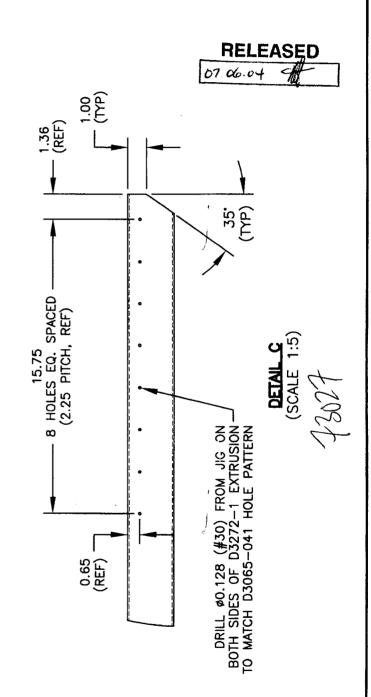
	BOTTOM OF TOP RADIUS \	
GRIND FLUSH (TYP)  3.375	RIVET D3065-041 TO D3272-1 USING MS20600AD4W4 RIVET  (16 PLACES)	1.36 (REF) 0.65 (REF)
D3219- SUPPOR (REF)	الاستان المستعدد المس	
D3067-1 END PLATE (2 PLACES)	D3066-1 SPACER (2 PLACES)	RELEA
<b>DETAIL B</b> (SCALE 1:5)	D3065-041	SED
	73017	

W/O:	·····		WC	ORK ORDER CHANGE	:e				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposition	າ:	QA: N/C Cld	osed:		Date: _	
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DATE	STEP	Description of NC	otion of NC Corrective Action		n B	Verific	ation	Approval	Approval
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DESIGN	DRAWN BY	DART AER()SPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED /	DRAWING NO.	REV. B
LE		D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20





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						-						
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Part No:		PAR #:	_ Fault Ca	tegory:	NCR: Yes No DQA:				Date:			
	R	esolution:	Disposit	ion:	QA	QA: N/C Closed:			Date:			
NCR:		<b>V</b>	ORK OR	DER NON-CONFORM	ANCE	(NCR)		- <del></del>				
DATE	STEP	Description of NC Section A	Corrective Action Section		tion B	Verification			Approval	Approval		
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